

5/43

DART AEROSPACE LTD		Work Order:	24536
Description: 206 L/L-1/L-3/L-4 HighGear Web		Part Number:	D2654-7
04.08.17 F8 04.08.17 Q1			
Drawing: D2654 Rev. D E1		Qty:	1

Step	Location	Procedure	By	Date	Qty.
1	EXPEDITING	Issue Work Order	JJ	05.10.12	1
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-7 Web B21130	Pm ^c	05-10-13	1
3	METAL	Cut D2600-7 to length as per Dwg D2654 (116.00") 04.07.07	Pm ^c	05-10-13	1
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	Pm ^c	05-10-13	1
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	Pm ^c	05-10-13	1
6	METAL	Deburr holes and ends	Pm ^c	05-10-13	1
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	Pm ^c	05-10-14	1
8	QC	Inspect Level 5	DP	05-10-18	1
9	METAL	Identify and stock	DP	05-10-18	1
10	EXPEDITING	Close Work Order Cost/part: 54.11 S4C 05/10/19 ①	DP	05/10/18	1

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	CS

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

RELEASED
DM 99.02.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

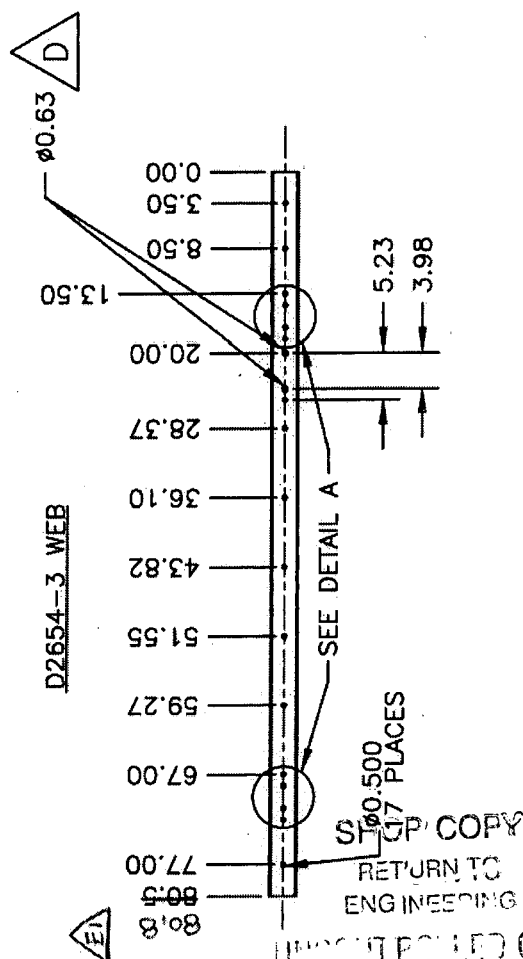
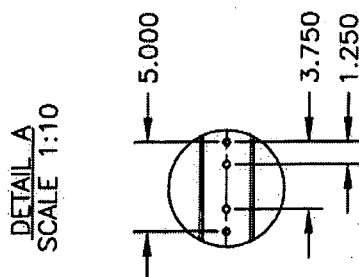
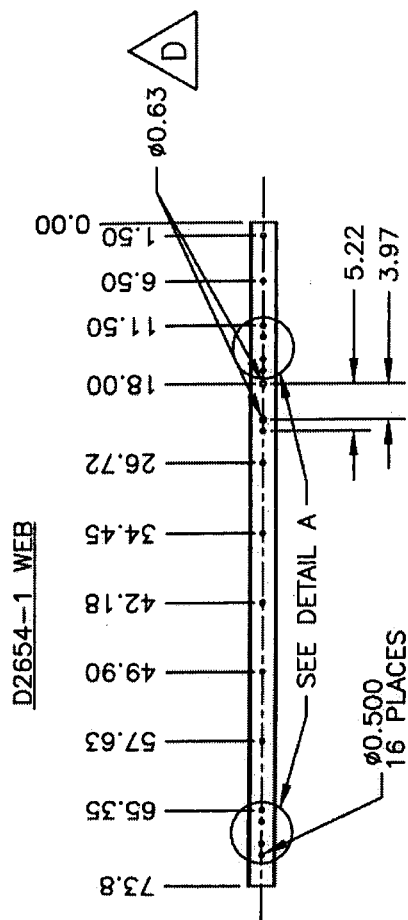
NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/10/18

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO Ø0.63	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 <i>CP</i>	<i>#</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
TERRITORY OF THE UNITED STATES
FIGHT NOTICE
WORK ORDER

24536

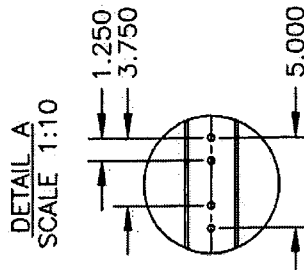
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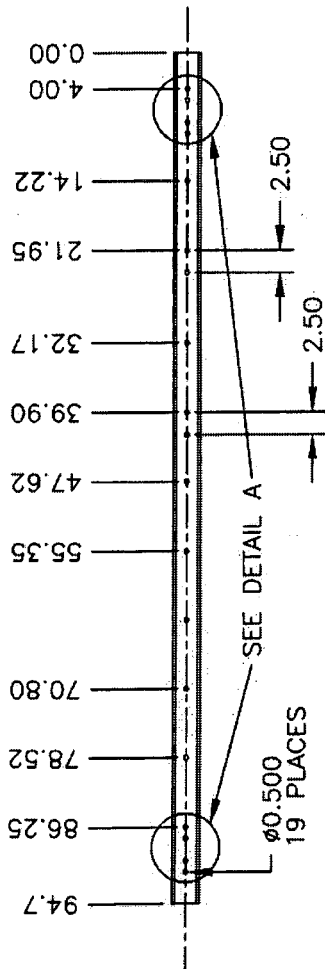


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

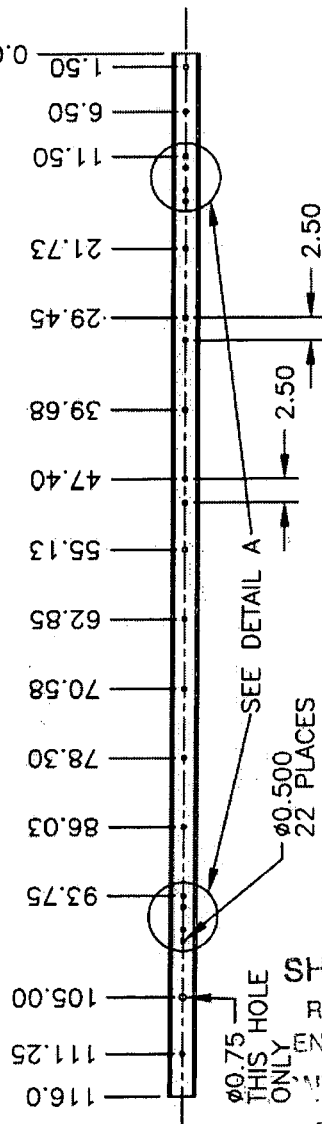
RELEASED
04.06.22



D2654-5 WEB



D2654-7 WEB



THIS HOLE ONLY
RETURN TO
ENGINEERING
FOR REVIEW
WITHOUT NOTICE

WORK ORDER

NO. 24536

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
11:50 am

Work Order No : 0024536
Project Name : D2654-7
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D2654-7
Description : 206 I Beam (Web)
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 10-11-05
Est Finish Date : 10-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00